BAP PLEASE

Work Order ID 61243

Page 1

Wednesday, Aug	gust 11, 2010	11:36:43 AM		1981 81 81	#12 11811 #1848 1 111 1 28 1						1
Item ID: Revision ID:	D3859-041			Accept				iii s	etup Stai	1 189111	
Item Name: Start Date: Required Date: Reference:	Wearplate 8/12/2010 8/26/2010	Start Qty: 6.00 Req'd Qty: 6.00			Cust Iten Custome				Sto	1 (834)))	
Approvals:	Process Pla	an:	Date:	Tooling:		Date:		F	tun Stai		
				SPC (Y/N):		Date:			Sto	P	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Numbe	Insp. er Stamp
Draw Nbr	Rev	vision Nbr									
Waterjet		FLOW WATER JET Memo		0.00 0.00				IB (C	2-8-18		
FLOW CNC Waterj		Deburr if n	·	Rev: A □Prog Rev:	□2-						8
110 		QC2- Inspect parts off r	machine FAI/FAIB	0.00				BIG	<u> </u>	-	
Quality Control 120 QC Quality Control		QC8- Inspect parts - sec	cond check	0.00				8			J1008:11
Quality Control										1	/

W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date: _	
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NCR:			WORK ORDE	ER NON-CONFORMA	ANCE (NO	R)			-
DATE	STEP	Description of NC			ion B	Verifi	cation	Approval	Approval
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Work Ord Wednesday, Au											Page 2
Item ID: Revision ID: Item Name:	D3859-041 Wearplate			Accept				S	Setup Star	1 188144	## ###################################
Start Date: Required Date Reference:	8/12/2010	Start Qty: 6.00 Req'd Qty: 6.00		·	Cust Item l Customer:	ID:			,		
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••						ate:			Sto	₽	
Sequence ID/ Work Center 130 Large Fab Large Fab	ID	Batch: <u>M</u> 2059B Hard	<i>145</i> 09_ □2-Weld I	Set Up/ Run Hours 0.00 0.00 0.00 3859 A/R 316L stain hard facing as per Dwg D3	Tool ID aless steel rod 859 A/R *****use	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Numbe	er Stamp
QC Quality Control		QC9- Inspect visual per Memo	QSI004- Fusion Welds	0.00				8 1	<u>0.0</u> 0 (1	અ	

150 QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

W/O:			W	ORK ORDER CHANGI	ES				
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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rait NO		PAR #:							
	He	solution:						Date: _	
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DATE	STEP	Description of NC	Initial	Corrective Action Section Action Description	on B Sign 8		cation	Approval	Approval
		Section A	Chief Eng	Chief Eng	Date		ion C	Chief Eng	QC Inspector
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	<u>. </u>								
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Work Orde Wednesday, Aug										Page 3
Revision ID: Item Name:	D3859-041 Wearplate 8/12/2010 8/26/2010	Start Qty: 6.00 Req'd Qty: 6.00		Accept	Cust Item ID: Customer:	11 1111 1111 1111	s	etup Start Stop		1114 11 11 11 11 11 11 11
Approvals: Sequence ID/ Work Center II	QC:	Operation Description Grey Sandtex(Ref: 4.3.5.6	Date:	Set Up/		ol# Plan Code	Accept Qty	Stop Reject Qty	į	Insp. The Stamp
Powder Coating 170 QC	,	Memo START TIM	E: S.S. OFINISH TIME:	0.00 OVEN TEMPERATUR 0.00 0.00 0.00	ne:			\$ ·		
Quality Control		WICHIO			_	•		•		

180

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

Packaging

W/O:			WO	RK ORDER CHAN	GES				
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part Nc	:	PAR #:	Fault Cated	iorv:	NCR: Yes	No DG) A :	Date:	
		solution:							
NCR:			WORK ORDE	R NON-CONFORM	IANCE (NCF	R)			.
DATE	STEP	Description of NC			ction B	Verifi	cation	Approval	Approval
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Work Order ID 61243

Wednesday, August 11, 2010 11:36:43 AM



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Item ID:

D3859-041

Accept

Setup Start

Stop

Revision ID:

Start Date:

Item Name:

Required Date: 8/26/2010

Wearplate

8/12/2010

Start Qty: 6.00

Req'd Qty: 6.00



Date:

Cust Item ID:

Customer:

Reference: Approvals:

QC:

Process Plan:

Date: Tooling:

SPC (Y/N):

Date:

Date:

Start Run

Stop

Sequence ID/

Work Center ID

190

Operation Description

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours**

0.00

Tool ID

Tool # Plan Code

Reject Accept Qty

Reject Number

Insp. Stamp

Memo

0.00

Qty

Quality Control

W/O:			WC	RK ORDER CHANG	GES			to	
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	gory:	NCR: Ye	s No [DQA:	Date: _	
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NCR:			WORK ORDI	R NON-CONFORM	ANCE (NO	CR)			
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		Section A	Initial Chief Eng	Action Description Chief Eng	Da		Section C	Chief Eng	QC Inspector
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Picklist Print

Wednesday, August 11, 2010 11:36:43 AM

Work Order ID: 61243

Parent Item: D3859-041

Parent Item Name: Wearplate



Start Date: 8/12/2010

Required Date: 8/26/2010

Page 1

Start Qty: 6.00

Required Qty: 6.00

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IPP Rev:A 09-02-03 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date State
M304S16GA		Purchased	No			100	sf	0.0267	0.85	5.1	B.8	8-18
D3009-3		Manufactured	No	<u>Location</u> MAT	111323 114799	0.02669 0.02666 130	4737 0	<u>Loc Code</u> 305.0000	-	36 E	7_10	9-20
Сир				Location	1	Loc (<u>Oty</u>	Loc Code				
				WA	42377		305 305		_	46		

W/O:			WC	ORK ORDER CHANGI	ES				
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DART AEROSPACE LTD	Work Order:	61243
Description: Wearplate	Part Number:	D3859-1
Inspection Dwg: D3859 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

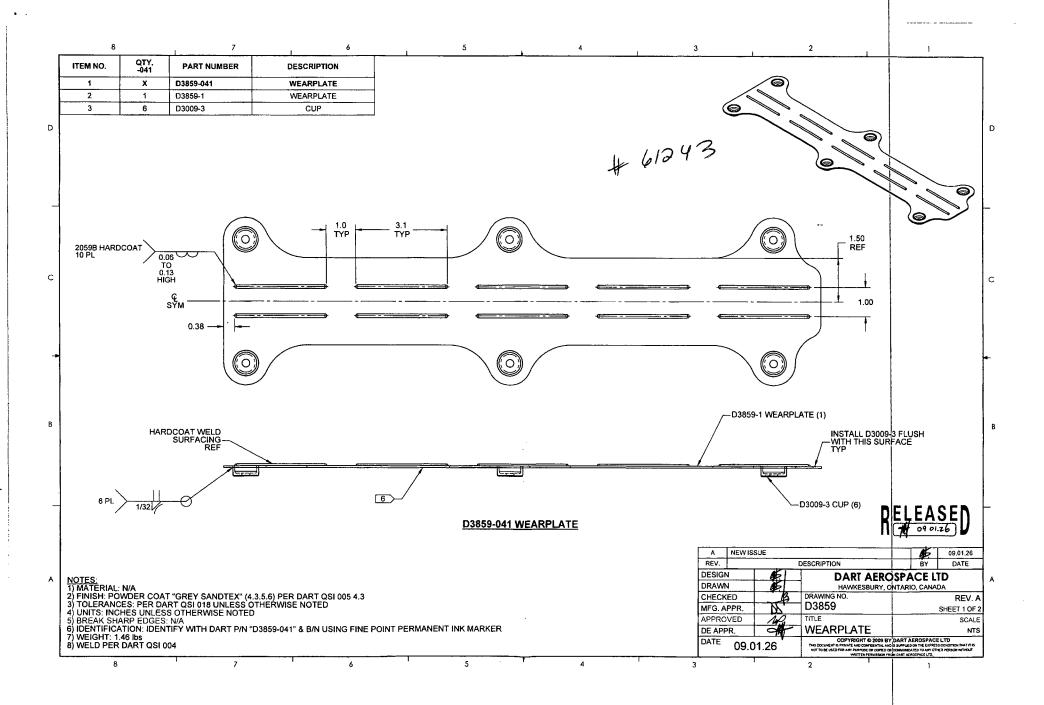
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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0.75	+/-0.030	1749	×		J	
4.250	+/-0.010	4.247	>		V	
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5.75	+/-0.030	5,746	>		ν	
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Measured by: Audited by: Prototype Approval: N/A

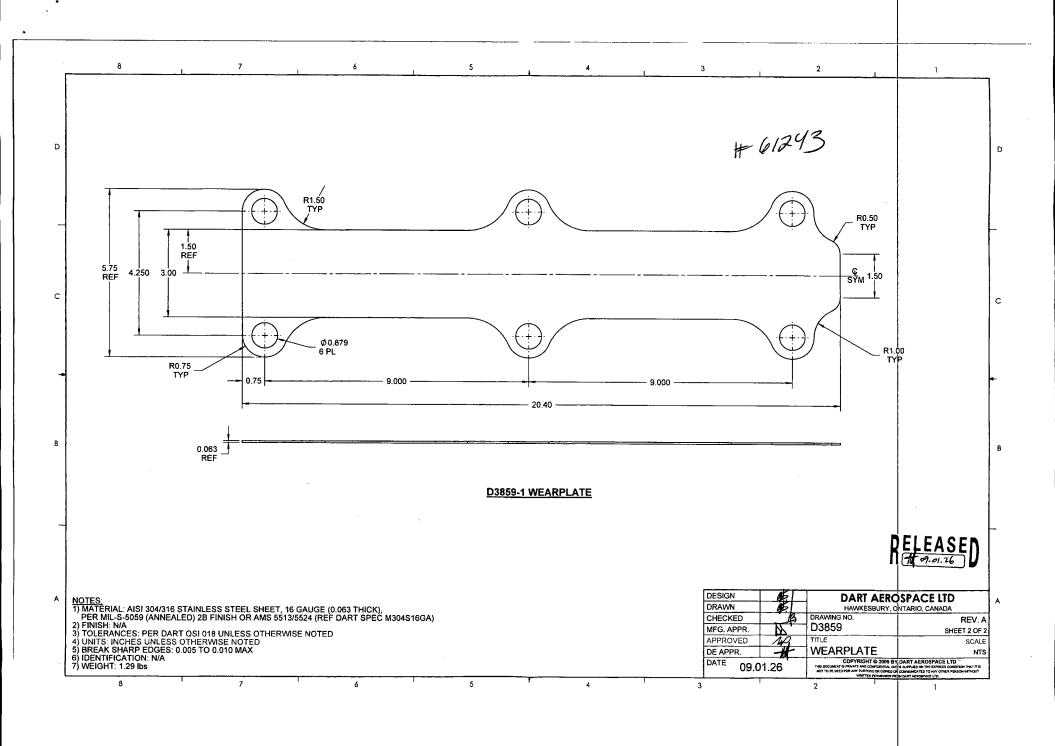
Date: Date: N/A

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Α	09.05.20	New Issue	P/O D3859-041	KJ	oxy	78
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